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(21) International Application Number: PCT/US94/09242 (22) International Filing Date: 16 August 1994 (16.08.94) (30) Priority Data: 08/107,967 16 August 1993 (16.08.93) US (71) Applicant: DONALDSON COMPANY, INC. [US/US]; 1400 West 94th Street, Minneapolis, MN 55440-1299 (US). (72) Inventors: TOKAR, Joseph, C.; 6205 137th Street West, Apple Valley, MN 55124 (US). WRIGHT, Mervin, E.; 501 Rimrock Drive, Apple Valley, MN 55124 (US). GRAFE, Timothy, H.; 4330 Abbott Avenue South, Minneapolis, MN 55410 (US). LEBLANC, James, A.; 18830 Pheasant Circle, Eden Prairie, MN 55344 (US). (74) Agent: BRUESS, Steven, C.; Merchant, Gould, Smith, Edell, Welter & Schmidt, 3100 Norwest Center, 90 South Seventh Street, Minneapolis, MN-55402 (US).		(81) Designated States: AU, BR, CA, JP, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i>	
(54) Title: MIST COLLECTOR CARTRIDGE			
(57) Abstract <p>A mist collector cartridge for collecting airborne liquids, and more particularly, a filter media having vertically oriented interconnected pleats treated with a low surface energy material to facilitate agglomeration and drainage of liquid which accumulates on the inner and outer surface of the filter media.</p>			

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MIST COLLECTOR CARTRIDGE

FIELD OF THE INVENTION

The present application relates to a mist
5 collector cartridge and a filter cartridge retention
system. The present mist collector cartridge invention
relates to a filter cartridge for collecting airborne
liquids, and more particularly, a filter media having
vertically oriented interconnected pleats treated with a
10 low surface energy material to facilitate agglomeration and
drainage of liquid which accumulates on the inner and outer
surface of the filter media. The filter cartridge
retention system relates to a mechanism for releasably
retaining the filter cartridge between an operational
15 position in fluid communication with an exhaust port in a
filtration system and a released position for removal of
the cartridge from the filtration system.

BACKGROUND OF THE INVENTION

20 The metal working industry utilizes various
coolants and lubricants during cutting and forming
operations. These fluids range from pure oils, oil and
water mixtures, and non-oils synthetics. Because of the
forcefulness with which these fluids are applied during
25 metal working operations and the heat generated where the
cutting tool meets the workpiece, a fine mist or aerosol in
the 0 to 2 micron range is generated. To arrest this mist,
a high efficiency filter is required.

If the machine tool is free standing, the aerosol mist can be pulled away from the area using a hood over the cutting area. Alternatively, newer machine tools now employ enclosures around the cutting area, which allow the
5 mist to be withdrawn from a single location.

Filters that have traditionally been used for mist collection originated in the heating, ventilation, and air conditioning (HVAC) industry. These filters generally incorporate a fiberglass mat with a synthetic non-woven
10 layer on the backside for additional strength. This material can be fabricated in a variety of styles such as folded pockets, cassettes, etc., typically for use in a filtration cabinet.

A system widely in use for aerosol mist collection
15 employs relatively thick filter bags which are folded into large pleats arranged with respect to the airflow, also known as pocket style HVAC filters. These pocket filters are typically not constructed with a separation structure, allowing the layers collapse under pressure.

20 The oil in the mist is absorbed by the relatively thick, porous pockets causing the bags to gradually become saturated with oil. The bags eventually collapse under the weight of the oil, causing the air to be forced through a smaller surface area. The reduced surface area of the
25 filter increases air velocity through the filter, resulting

in some of the oil being forced through the bags,
contaminating the downstream air.

Consequently, these filters have a generally
declining efficiency as the oil collects in the filter.

5 As a result of the declining efficiency, the pressure drop
across the filter does not increase, making it difficult to
determine when the filter needs to be replaced. Disposal
of such filters is also difficult because of environmental
concerns over their oil content.

10

SUMMARY OF THE INVENTION

The present filter system collects airborne
liquids in a filter media having vertical pleats with a
separation therebetween. The separation between the
15 vertical pleats is maintained by a pleat spacing
arrangement. The filter media is treated with a low
surface energy material so that liquids contacting the
inner or outer surface of the media agglomerate and drain
downward along the vertical pleats.

20 The low surface energy coating is preferably an
aliphatic fluorocarbon.

Liquid which accumulates on the inner surface of
the filter media drains downward into a bottom cover where
it is diverted away from the downstream air.

25 The filter media preferably prevents airborne
liquid from entering the downstream air. Consequently the

filter media has increasing efficiency over time, which corresponds to a predictable change in pressure across the filter media over time. The predictable nature of the change in pressure across the filter media allows for predictive maintenance of the filter cartridge.

The filter cartridge may include a pre-filter wrap extending around the outer surface of the filter cartridge to cause the formation of larger droplets of the airborne liquid on the pre-filter wrap. These larger droplets more easily drain off of the filter cartridge.

A variety of pre-filter wraps are contemplated, including high loft air-laid or dry-laid materials, fully open cellular filtration foams, and fiber glass wool products.

The filter cartridge retention system relates to a mechanism for releasably retaining a filter cartridge within a filtration system between an operational position and a released position.

A support member is pivotally attached at one end within the filtration system for supporting the filter cartridge. End stops are provided on the support member for retaining the filter cartridge in proper alignment with an exhaust port in the filtration system. A handle is pivotally attached to the free end of the support member so that the support member can be moved between a generally horizontal operational position for engaging the filter

cartridge with the exhaust port and a reclined released position which allows the filter cartridge to be slid in or out of the filtration system. In order to move the support member to the generally horizontal position, the handle is
5 pivoted beyond the vertical position to insure that the filter cartridge is locked into position.

A compression gasket is preferably interposed between the filter cartridge and the exhaust port to ensure a fluid-tight fit of the filter cartridge within the
10 filtration system.

The handle is moved to a generally horizontal position in order to move the support member to the reclined released position. In this configuration, the handle operates as a slide ramp extension for the support
15 member to facilitate insertion and removal of the filter cartridge from the filtration system. As a safety feature, when the pivot handle is in the horizontal-released position, the door on the filtration system can not be closed.

20

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 illustrates a perspective view of a preferred mist collection system utilizing the preferred filter cartridge retention mechanism and mist collector
25 cartridge;

Figure 2 is a perspective view of a preferred filter cartridge retention mechanism in the operational position;

Figure 3 is a perspective view of a preferred filter cartridge retention mechanism in the reclined and released position;

Figure 4 is a perspective view of one embodiment of the mist collector cartridge with a multiple layer pre-filter wrap;

Figure 5 is a top view of the mist collector cartridge of Figure 4;

Figure 6 is a sectional view of the preferred mist collector cartridge using multiple layers of non-woven air-laid material as a pre-filter wrap; and

Figure 7 is a flow chart illustrating the method of manufacturing the preferred mist collector cartridge.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

Figure 1 illustrates a mist collection system 10 for use with the preferred mist collector cartridge 12. It will be understood by those skilled in the art that the illustrated mist collection system 10 is set forth only by way of example and is not intended to limit the scope of the invention. It will also be understood that the preferred filter cartridge retention mechanism 14 and mist collector cartridge 12 may be used in any suitable

filtration system and are not limited to the illustrated mist collection system 10.

The mist collection system 10 preferably comprises a housing 16 with an upper chamber 18 and lower chamber 20 separated by a dividing wall 22 having an exhaust port opening 30 (not shown). The upper chamber 18 preferably contains a blower housing 26 and motor 28 in fluid communication with the mist collector cartridge 12 by way of the exhaust port 30 (not shown).

10 A fan (not shown) in the blower housing 26 draws contaminated air into the lower chamber 20 through an air inlet port 24. The contaminated air is drawn through the sidewalls of the mist collector cartridge 12 and expelled through a blower opening 31 into the upper chamber 18. As
15 pressure in the upper chamber 18 increases, the filtered air is forced through an outlet port 32 in the top of the mist collection system 10. A high efficiency particulate air (HEPA) filter (not shown) may be installed proximate the outlet port 32 in the upper chamber 18 as a final stage
20 filter.

A door 34 is provided on the front of the lower chamber 20 through which the mist collector cartridge 12 can be inserted or removed. An upper screen 36 and lower screen 38 are preferably located in the lower chamber 20 of
25 the mist collection system 10 above and below the air inlet port 24, respectively. The upper and lower screens 36,38

prevent particulates, such as metal shavings, from being drawn into the mist collection cartridge 12 or from falling into a hopper 40 at the bottom of the mist collection system 10.

5 The mist collector cartridge 12 is preferably retained in the lower chamber 20 of the mist collection system 10 by the filter retention mechanism 14. The preferred filter cartridge retention system 14 contains a pair of V-shaped angled slides 50 which extend from a rear
10 pivot bracket 52 mounted on the rear of the mist collection system 10 to a front bracket 54 attached to the mist collection system 10 proximate the door 34.

 Figure 2 illustrates the preferred filter cartridge retention system 14 locked in the operational
15 position. A pair of support members 56 are pivotally attached to the rear pivot bracket 52 by a rear pivot rod 58. A pair of filter cartridge end stops 60 are attached to the support members 56 so that the mist collector cartridge 12 is correctly position within the filtration
20 system 10 in fluid engagement with the exhaust port 30 in the dividing wall 22 (See Fig. 1). An elongated handle 62 is pivotally attached to the free ends of the support members 56 by a front pivot rod 64. The handle 62 preferably has a pair of feet 66 which simultaneously rest
25 in the angle slides 50 and are wedged against the front bracket 54. The length of the support members 56 is

determined so that the angle σ of the handle 62 with respect to the support members 56 is less than 90° .

Consequently, the filter cartridge retention system 14 is capable of exerting significant upward force on the filter cartridge 12 without a danger of disengagement. The feet 66 of the handle 62 are preferably beveled (See Fig. 3) on the base of the handle 62 facilitate sliding in the angled slides 50. In the operational position, the beveled surfaces of the feet 66 rest securely against the back surface of the front bracket 54.

Figure 3 illustrates the filter cartridge retention system 14 in a reclined or released position. The feet of the handle 66 ride in the V-shaped angled slides 50 as the handle 62 is moved forward away from the mist collector cartridge 12. When the handle 66 is in the horizontal position, the support members 56 are angled downward toward the door 34 to allow easy insertion or removal of a mist collector cartridge 12. The handle 62 operates as an extension 68 of the support members 56 to facilitate insertion and removal of a mist collector cartridge 12. When the handle is in the horizontal position, it extends out from the doorway, preventing the door 34 from being closed unless the filter cartridge retention system 14 is in the operational position.

It will be understood by those skilled in the art that the components of the filter cartridge retention

system 14 can be changed or modified without departing from the spirit or scope of the invention. For example, the support members 56 may be replaced by a single rigid pivot member. Likewise, the handle may be configured as a solid member pivotally attached to a support members.

Figure 4 illustrates an embodiment of the mist collector cartridge 12 of the present invention. Filter support members 80 preferably include a circular top member or top end cap 82 having a top opening 84, perforated inner and outer filter sidewalls or liners 86,88 and a bottom end cap 90 (See Fig. 5). The top end cap 82 preferably contains a compression gasket 78 to insure fluid tight engagement with the exhaust port 30. The support members 80 may be constructed of any suitable material, including metal or plastic.

The perforated outer filter sidewall 88 is preferably covered with a pre-filter wrap 91. The pre-filter wrap illustrated in Figs. 4 and 5 comprises a corrugated outer wrap 92 and a generally flat inner wrap 94. The inner and outer pre-filter wraps 92,94 may be joined by a seam (not shown) along hook and loop portions 96,98. Such hook and loop fasteners 96,98 are sold under the trade name VELCRO. The pre-filter wrap 91 is attached to the filter support members 80 by use of the hook and loop fastener material 96,98 on the edges of the pre-filter wrap 91 (See Fig. 5).

The pre-filter wrap 91 may be constructed of a foamed urethane material, also referred to as a fully open cellular filtration foam. A foam material suitable for this purpose is available under the trade name Filter Foam from Scott Foam Inc., Chester, PA. The outer wrap 92 is preferably more porous than the inner wrap 94, allowing it to hold a greater quantity of liquid. The outer wrap 92 is preferably 0.75" thick, with approximately 45 pores/inch. The inner wrap 94 is preferably 0.25" thick with approximately 100 pores/inch. In operation, the foamed urethane wrap 91 holds liquid, but does not build resistance to air flow.

Figure 6 illustrates a sectional view of the preferred mist collector cartridge 12' of the present invention. The bottom end cap 90 preferably has a sloped portion 100 which allows oil that is collected on the inner surface 102 of cartridge 12' to drain through filter media 104 and into the hopper 40.

The filter media 104 preferably comprises a synthetic glass and polyester material arranged to form a cylindrical pleated filter cartridge. The filter media 104 preferably has a high efficiency, between 70 and 90 percent at .778 micron particles.

To keep pleats 107 correctly spaced, the filter media 104 is scored to create alternating rectilinear line portions 118 and curvilinear line portions 120. During the

corrugation process, dimples 109 are integrally formed in the filter media 104 along the pleat tips 106 to maintain the spacing between the pleats 107. Construction of a corrugated filter media of this type is disclosed in U.S.

5 Patent No. 4,452,619, issued to Wright et al. on June 5, 1984, which is hereby incorporated by reference into this specification.

As will be discussed below, as dirt and oil accumulate on the filter media 104, the media 104 become
10 partially clogged so that the air flowing through the filter media 104 accelerates to create additional pressure on the filter media 104. In order for the filter media 104 to withstand the increased pressure, the pleats 107 are preferably space more closely together than on an air
15 filter, giving the filter media 104 additional structural integrity. Because pleats on an ordinary air filter are generally spaced further apart, they would probably collapse under the air pressure in the present mist collection system.

20 The filter media 104 is preferably a low surface energy synthetic fiber matrix constructed from fibers having a thickness of less than .030". The filter media 104 may be treated with a low surface energy material, such as an aliphatic fluorocarbon. One low energy coating
25 suitable for this purpose is sold under the trade name Scotchguard® or Scotchban® Protector, by 3M Corporation,

St. Paul, MN. Scotchban[®] Protector is described in brochure entitled Introducing FX-845 Scotchban Chemistry Takes On A New Life, dated 1991, which is hereby

5 incorporated by reference into this specification. Low surface energy coatings and low surface energy materials create a low surface energy on the filter media 104 which facilitates agglomeration of the oil and promotes drainage. The pre-filter wraps 91, 110 may also be treated with a low
10 surface energy material.

As is illustrated in Figure 6, the filter media 104 is preferably recessed or set back from the inside surface of the outer liner 88 so that a space 89 is formed between the outer liner 88 and the filter media 104. The
15 space 89 allows most of the oil that penetrates the pre-filter wrap 91 to form droplets on the inside surface of the pre-filter wrap 91 or the outer liner 88, rather than on the filter media 104.

The pleats 106 are arranged vertically in the
20 cartridges 12, 12'. The filter media 104, and inner and outer liners 86, 88 are retained in the top and bottom end caps 82, 90 by a filter media adhesive 108, such as plastisol. The hook portion 96' of a fastener material may be retained between the outer liner 88 and the top end cap
25 82 around the perimeter of the mist collector cartridge 12'.

by the adhesive 108. The pre-filter wrap 91 may then be attached directly to the mist collector cartridge 12, 12'.

Oil mist too fine to collect on the outside surface of the filter media 104 may emerge on the inner surface 102 of the pleats 106. The vertical pleats 106 allow liquid collected on the inner surface 102 to drain downward onto the bottom end cap 90 of the cartridges 12, 12', where it passes through the filter media 104 and into the hopper 40.

10 The filter media 104 is preferably constructed according the flow chart illustrated in Figure 7. The flat filter paper stock is preferably dipped in a low surface energy coating material 130, such as an aliphatic fluorocarbon. It should be understood that the paper stock
15 may be treated or wetted by a variety of methods, including spraying. The excess coating material is removed by compressing the coated paper stock between a pair of compression rollers 132. The coated paper stock is then dried in a convection drying oven 134.

20 Prior to pleating, the paper stock is corrugated 136 by pressing a series of grooves lengthwise along the paper with a heated roller. The paper stock is then pleated 138 to form the filter media 104 and inserted into a filter housing 140. The preferred corrugation process is
25 disclosed in U.S. Patent No. 4,452,619, issued to Wright et al., previously incorporated by reference into this

specification. It will be understood that the cylindrical filter cartridge illustrated herein is set forth by way of example only and that a variety of filter configurations are possible. For example, generally planar filter

5 cartridges having suitable drainage mechanism may be used in place of the cylindrical cartridge.

Figure 6 also illustrates the preferred pre-filter wrap 110 of the present invention. The pre-filter wrap 110 is preferably constructed of multiple layers of non-woven
10 air-laid mediums, such as high loft air-laid or dry-laid materials. Because of the nature of the pre-filter wrap 110, it may be attached directly to the hook portion 96' without the use of the mating hook-portion.

In the preferred embodiment, the outer pre-filter
15 layer 112 is approximately 0.75" of open material having a density of 6.7 ounces/sq.yd. and a solidity of 0.8%. A product meeting these specifications is sold under the trade name Airlaid Media by Comulus Fiber Corp. located in Charlotte, NC. The two inner layers 114, 116 are
20 approximately 0.25" of a high efficiency material having a density of 3.62 ounces/sq.yd. and a solidity of 1.6%. A product meeting these specifications is available from Chemwove Corp. in Charlotte, NC.

The preferred pre-filter wrap 110 accumulates oil
25 during operation of the mist collection system 10. As oil accumulates, the pressure drop across the filters 12, 12'

increases. When the motor 28 in the blower housing 26 is turned-off, the oil accumulated in the pre-filter wrap 110 drains downward into the hopper 40. After the oil has drained, the pressure drop across the filters 12,12' is
5 reduced, thereby extending filter life.

In an alternate embodiment, the pre-filter wrap may be constructed of fiberglass or fiberglass wool filter media of various thicknesses and efficiencies, sold under the trade name Fiberglass Wool, by Schuller Filtration
10 Corp. located in Vienna, West Virginia. Fiberglass materials hold oil and increases the pressure drop across the filter as oil accumulates. By replacing the fiberglass pre-filter wrap periodically, the life of the filter media
104 may be extended.

15 Due to the low surface energy of the filter media 104, the media 104 retains less oil. In actual operation, oil droplets formed on the outside surface of the filter media 104 drain downward by gravity into the collection
20 hopper 40. Any oil that passes through the media 104 and agglomerates on the inside surface 102 drains by gravity to the sloped portion of the bottom end cap 90 and passes back through the filter media 104 into the hopper 40. The
agglomeration of the oil on the inside and outside surface of the media 104, in combination with the vertically
25 oriented pleats 106, ensures that almost no oil is bled into the downstream air. Thus, the filter media 104 does

not absorb the oil, but instead separates it and drains it off so that it can be collected and disposed of apart from the filter 12. In some applications, it is possible to recycle the collected fluid.

5 Further, because the filter media 104 is pleated, it has a large surface area which allows air flowing through the media 104 to move at a low velocity, reducing the tendency of oil to be blown off the inner surface 102 of the filter 12 into the downstream air.

10 In the preferred embodiment, the efficiency and pressure drop across the cartridges 12,12' increase over time. The mist collector cartridge 12,12' function for a long period of time because the media 104 does not become saturated with oil. As the filters 12,12' become clogged
15 with dirt and other particulates, the efficiency and the pressure drop across the filters 12,12' increases. Therefore, the pressure drop across the filter 12,12' corresponds to the amount of useful life remaining in the filters 12,12', which can be used to indicate when the
20 filters 12,12' need to be replaced.

It will be understood by those skilled in the art that the present inventions are not limited to the examples discussed above, but may be changed or modified without departing from the spirit or scope of the invention. For
25 example, a wide variety of filter cartridge configurations may be used in combination with a variety of drainage

mechanisms. Further, it will be recognized that a variety of low surface energy fiber media may be utilized to facilitate the agglomeration and drainage of the collected oil.

What is claimed is:

1. A filter system for collecting airborne liquids, comprising:

a filter media having vertical pleats with a
5 separation therebetween, and an inner and outer surface;
pleat spacing means for maintaining the separation
between the vertical pleats; and

filter treatment means for treating the filter
media so that airborne liquids contacting the inner or
10 outer surface of the media agglomerate and drain downward
along the vertical pleats.

2. The apparatus of claim 1 wherein the filter
media comprises a low surface energy synthetic fiber
15 matrix.

3. The apparatus of claim 1 wherein the filter
treatment means comprises a low surface energy coating
material.

20 4. The apparatus of claim 3 wherein the low
surface energy coating material comprises an aliphatic
fluorocarbon.

25 5. The apparatus of claim 1 wherein the pleat
spacing means are integrally formed in the filter media.

6. The apparatus of claim 1 further comprising a pre-filter wrap extending across the outer surface of the filter media to promote the formation of large droplets of the airborne liquid.

7. A filter cartridge for collecting airborne liquids, comprising:

filter support members defining an air inlet surface and an air outlet surface;

a filter media within the filter support members for filtering air flowing from the inlet surface, through the filter media, and out through the outlet surface, having vertical pleats with a separation therebetween and an inner and outer surface; and

filter treatment means applied to the filter media for agglomerating liquid carried by the air and contacting its inner or outer surfaces and for draining the liquid downward along the vertical pleats.

8. The apparatus of claim 7 wherein the filter media includes pleat spacing means for maintaining the separation between the vertical pleats.

9. The apparatus of claim 7 wherein the filter media includes pleat spacing means arranged for preventing

the pleats from collapsing due to resistance in air flow caused by collected liquids.

10. The apparatus of claim 7 wherein the filter
5 media comprises a low surface energy synthetic fiber matrix.

11. The apparatus of claim 7 wherein the filter
treatment means comprises a low surface energy coating
10 material.

12. The apparatus of claim 9 wherein the low
surface energy coating material comprises an aliphatic
fluorocarbon.
15

13. The apparatus of claim 8 wherein the pleat
spacing means are integrally formed in the filter media.

14. The apparatus of claim 7 further comprising a
20 pre-filter wrap extending across the air inlet surface of
the filter media to promote the formation of large droplets
of the airborne liquid.

15. The apparatus of claim 14 wherein the pre-
25 filter wrap comprises a foamed urethane material.

16. The apparatus of claim 14 wherein the pre-filter wrap comprises a fiber glass wool material.

17. The apparatus of claim 14 wherein the pre-
5 filter wrap comprises a high loft air-laid material.

18. The apparatus of claim 7 wherein the filter support members form a cylindrically shaped cartridge having a top end cap with an opening and a bottom end cap.

10

19. A filter cartridge for collecting airborne liquids, comprising:

filter support members defining an air inlet surface and an air outlet surface;

15

a filter media within the filter support members for filtering air flowing from the inlet surface, through the filter media, and out through the outlet surface, having vertical pleats with a separation therebetween and an inner and outer surface;

20

pleat spacing means arranged for preventing the pleats from collapsing due to resistance in air flow caused by collected liquids; and

25

filter treatment means applied to the filter media for agglomerating liquid carried by the air and contacting its inner or outer surfaces and for draining the liquid downward along the vertical pleats.

20. A filter cartridge for collecting airborne liquids, comprising:

filter support members including at least one
5 perforated cylindrical sidewall and at least one end cap,
the filter members defining an air inlet surface and an air
outlet surface;

a cylindrical filter media within the filter
support members for filtering air flowing from the inlet
10 surface, through the filter media, and out through the
outlet surface, the filter media having vertical pleats
with a separation therebetween and an inner and outer
surface;

connection means for connecting the filter media
15 and side wall to the end cap;

pleat spacing means arranged for preventing the
pleats from collapsing due to resistance in air flow caused
by collected liquids; and

filter treatment means applied to the filter media
20 for agglomerating liquid carried by the air and contacting
its inner or outer surfaces and for draining the liquid
downward along the vertical pleats.

21. The apparatus of claim 20 further including a
25 pre-filter wrap extending across the air inlet surface of

the filter support members to cause the formation of large droplets of the airborne liquid.

22. The apparatus of claim 20 wherein the end cap
5 comprises a bottom end cap having collection means for collecting liquid which drains from the vertical pleats.

23. A method for separating and collecting
airborne liquids using a filtration system, comprising the
10 steps of:

a) providing a filter media having vertical pleats with a separation therebetween and pleat spacing means for maintaining the separation between the vertical pleats, the filter media having an air inlet surface and an
15 air outlet surface;

b) treating the filter media with filter treatment means for agglomerating liquids which contact the media to promote drainage of the liquid downward along the vertical pleats;

20 c) forcing air containing the liquid from the air inlet surface of the filter media to the air outlet surface so that liquid is collected on the filter media; and

d) collecting liquid which drains from the
25 vertical pleats.

24. The method of claim 23 wherein the filter treatment means comprises a low surface energy coating material.

5 25. The method of claim 24 wherein the low surface energy coating material comprises an aliphatic fluorocarbon.

10 26. The method of claim 23 wherein the pleat spacing means are integrally formed in the filter media.

27. A method for constructing a filter cartridge for collecting airborne liquids, comprising the steps of:

- 15 a) treating filter paper stock with a low surface energy material;
- b) corrugating the filter paper stock;
- c) pleating the filter paper stock to form a filter cartridge; and
- 20 d) inserting the filter cartridge into a filter support member.

28. The method of claim 27 wherein the step of pleating the filter paper stock includes forming spacing means integrally in the filter media.

25

29. The method of claim 27 wherein the low surface energy material comprises an aliphatic fluorocarbon.

5 30. The method of claim 27 further including the step of removing the excess low surface energy material.

31. The method of claim 27 further including the step of drying the filter paper stock.

10

32. The method of claim 27 wherein the step of treating the filter paper stock includes dipping the filter paper stock in the low surface energy material.

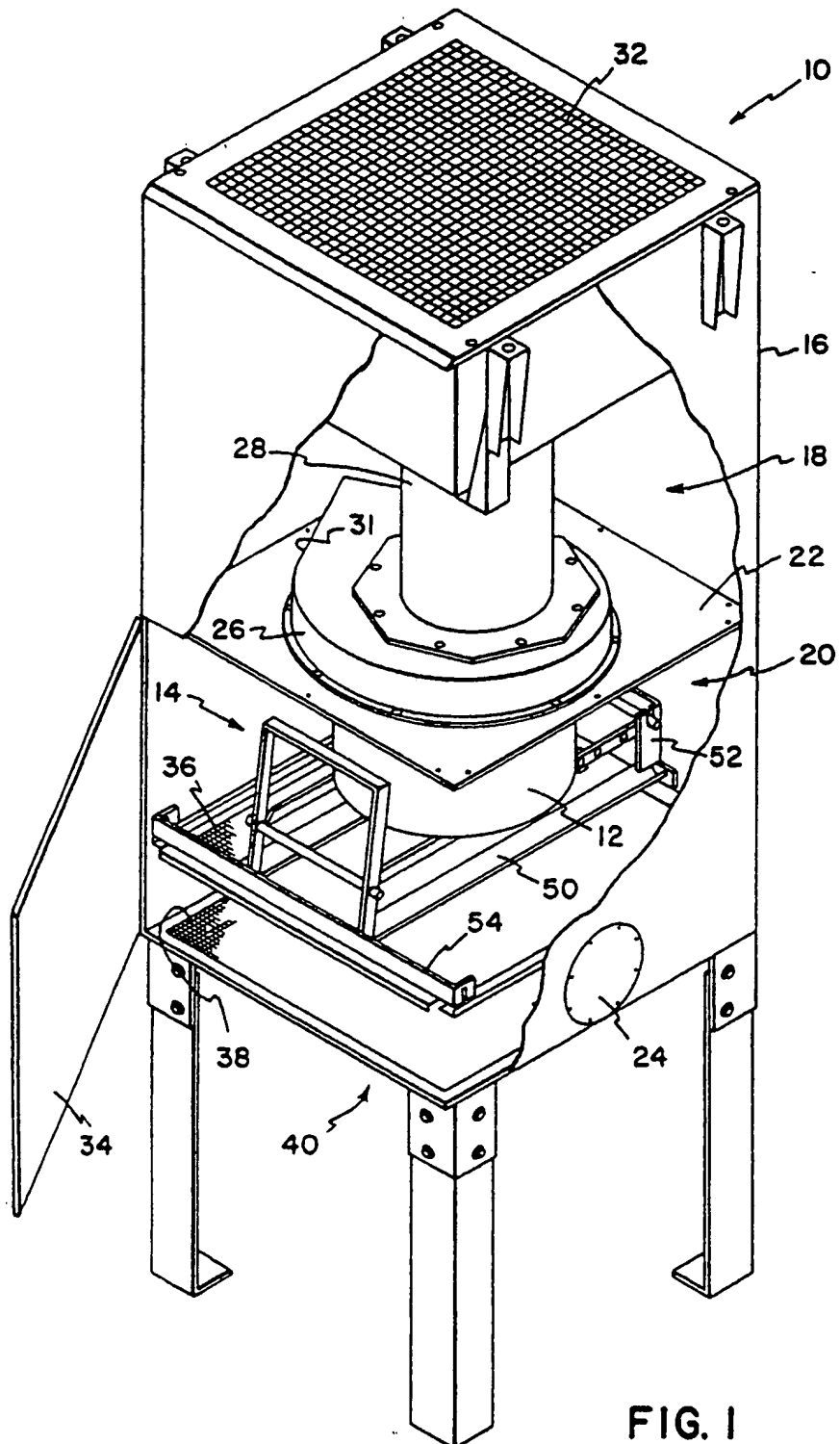
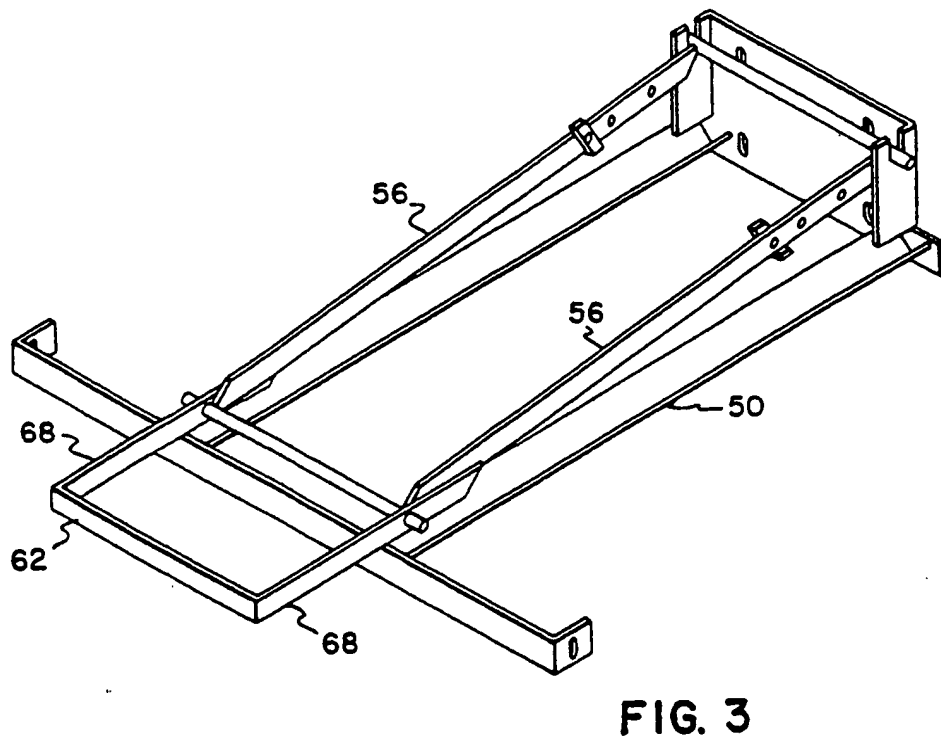
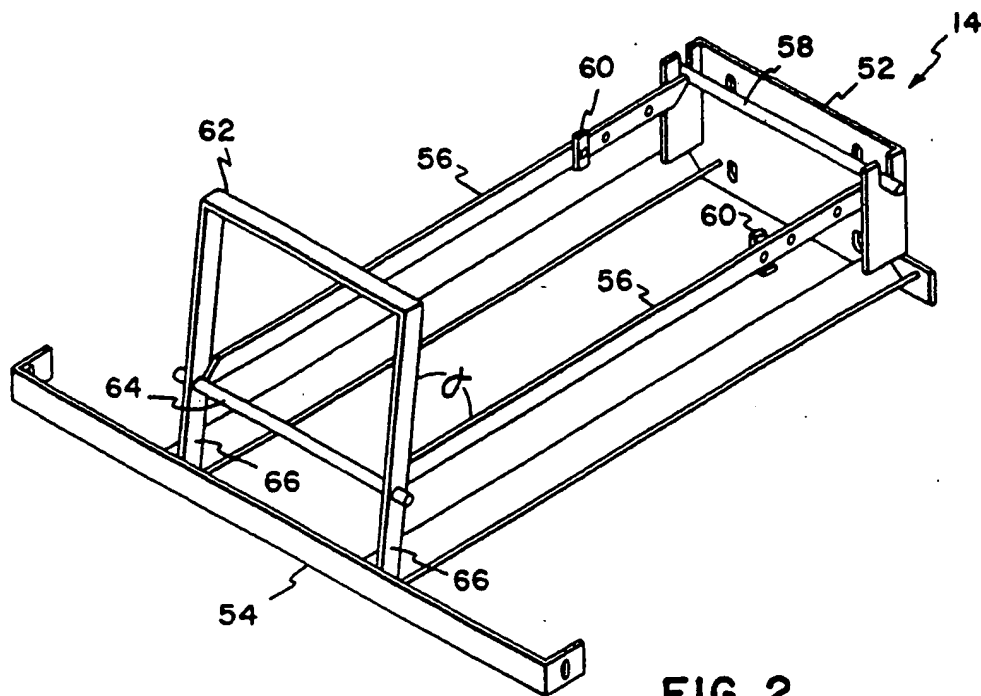
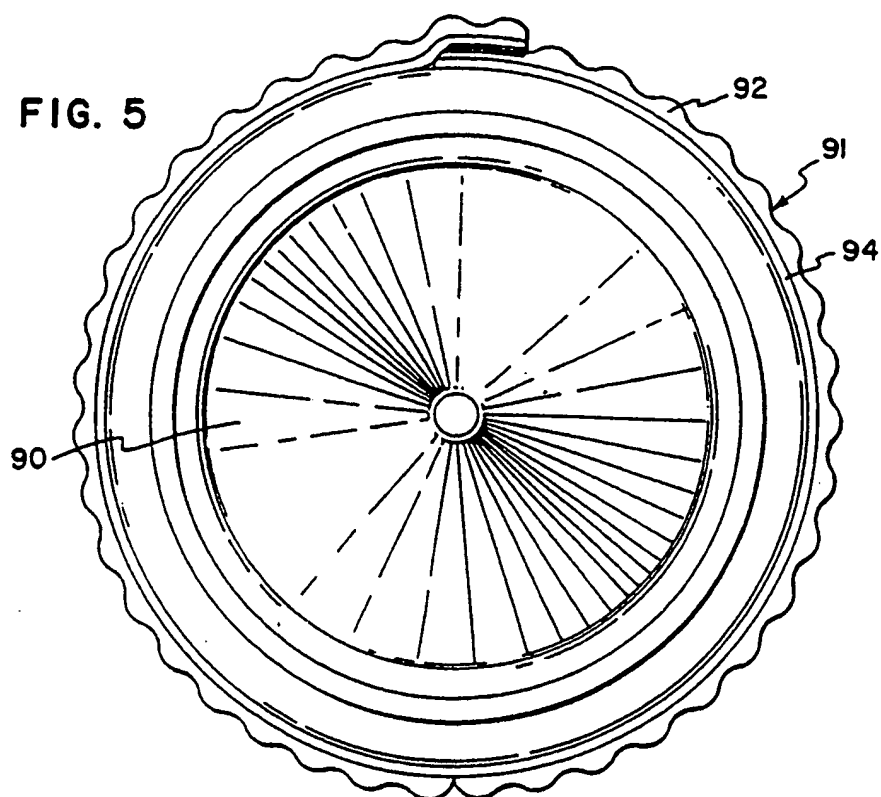
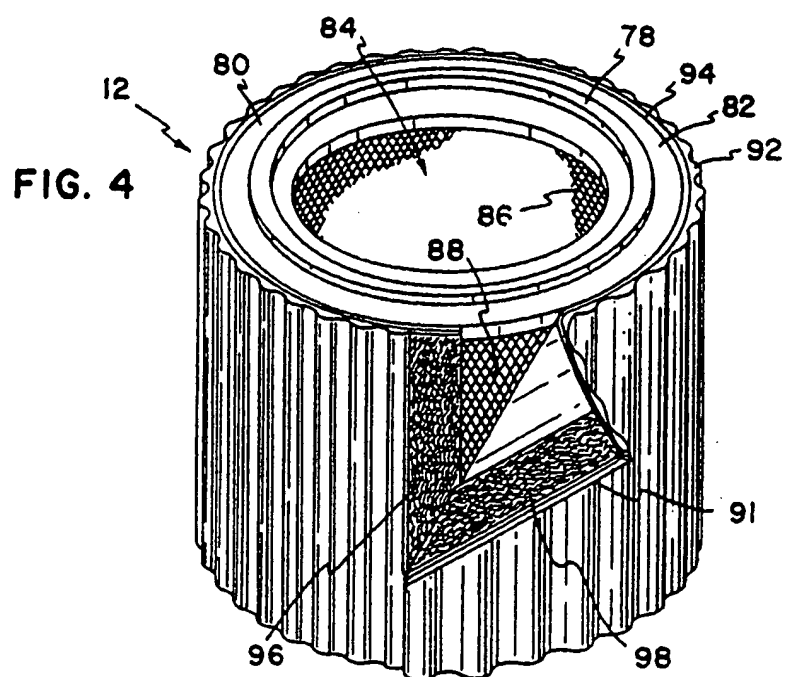


FIG. 1





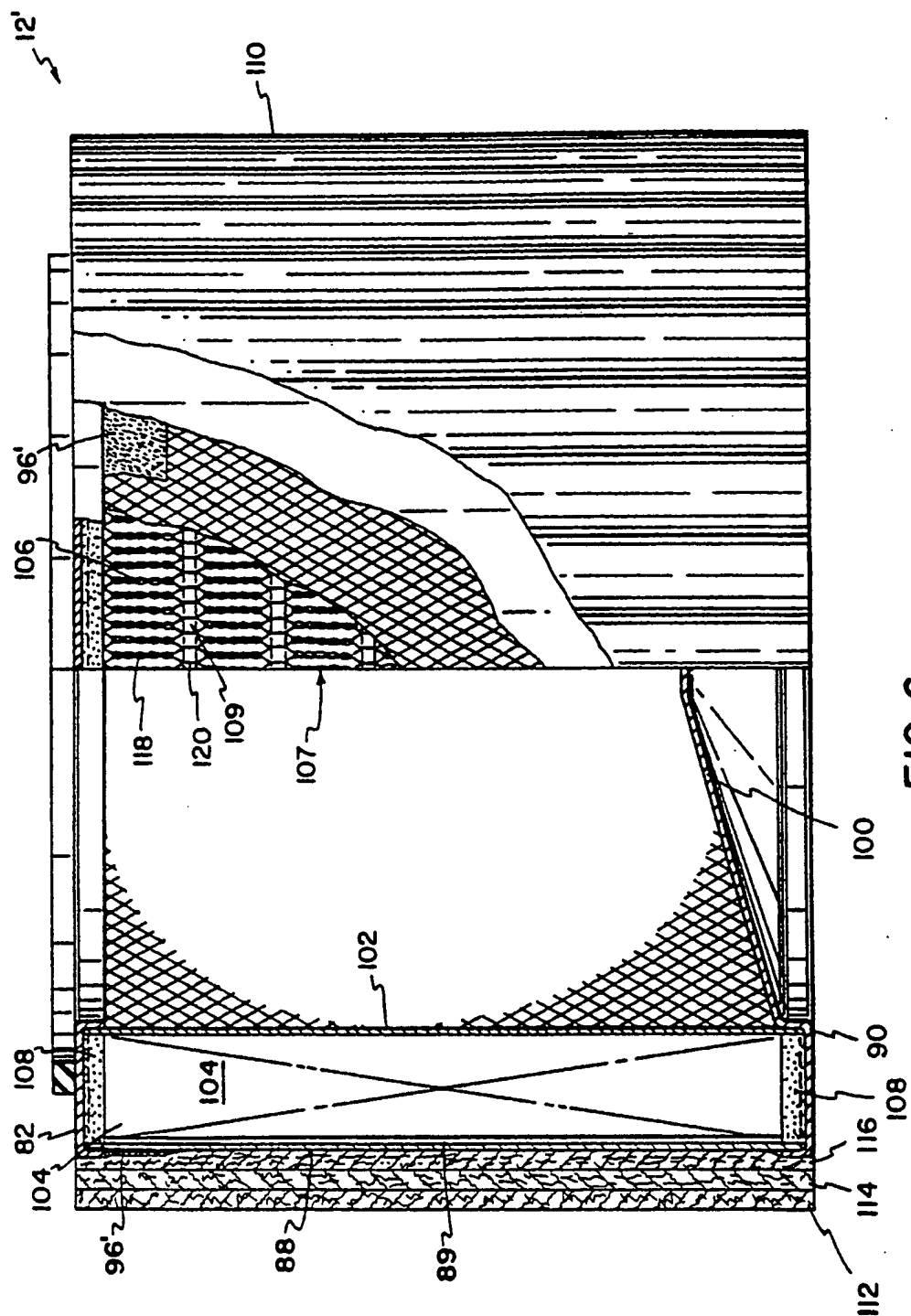
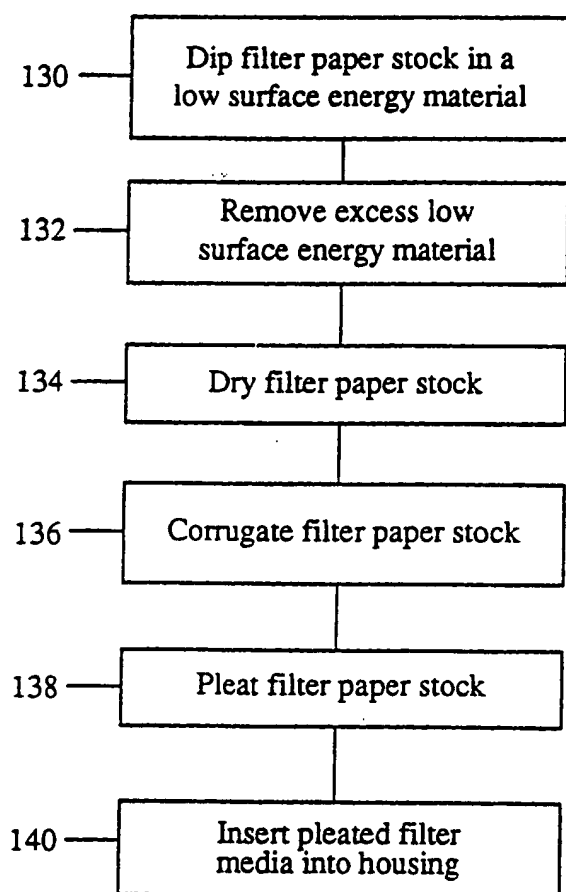


FIG. 6

Fig. 7

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US 94/09242

A. CLASSIFICATION OF SUBJECT MATTER

IPC 6 B01D46/24 B01D46/52 B01D39/16

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 B01D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	EP,A,0 208 515 (PALL CORPORATION) 14 January 1987 see the whole document ---	1-14, 18-32
Y	DE,A,34 44 387 (HR TEXTRON INC.) 11 July 1985 see page 9 - page 14; figures 1-10 ---	1-14, 18-32
A	WO,A,89 07484 (PROCESS SCIENTIFIC INNOVATIONS LIMITED) 24 August 1989 see page 2 - page 9; claims 1-10 ---	1,3,4,6, 11,12, 14,16, 18,22
A	US,A,4 160 684 (BERGER ET AL.) 10 July 1979 --- -/--	1,6,7, 18,19

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

25 November 1994

Date of mailing of the international search report

- 8. 12. 94

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INTERNATIONAL SEARCH REPORT

International application No.
PCT/US 94/09242

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	GB,A,2 197 802 (LOCKER AIR-MAZE LIMITED) 2 June 1988 see claims 1-16; figures 1,2 -----	1,6,7,15

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Information on patent family members

International application No.
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